Thursday, 18/06/2009 7:29:32 AM

User:

Chantal Lavoie

Process Sheet

Customer

This Issue

Prsht Rev.

Written By

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number : 48647 **Estimate Number** : 10162

P.O. Number

: 18/06/2009

: NC

: //

First Issue **Previous Run**

: 46165

: SMALL /MED FAB Type

Checked & Approved By

Comment

: Est D 04.05.31 Step 2 changed

Waterjet

Est E 06.07.31

EC

Drawing Name

: DOOR SLUG

Part Number

: D2587 : D2587 REV A1

: A1

Drawing Number

: N/A

Project Number

Drawing Revision

Material

Description:

Due Date : 24/06/2009 Qty:

20 Um:

Each

Additional Product

Job Number:



Seq. #:

1.0

2.0

Machine Or Operation:

6061-T6 .040 Sheet

KJ/JLM

M6061T6S040

0.0168 sf(s)/Unit Total:

6061T6 alum. sheet 0.040" thick

Batch: 100742

Comment: Qtv.:

FLOW WATER JET

0.3360 sf(s)



Comment: FLOW WATER JET

WATER JET

1-Cut as per Dwg D2587

Dwg Rev: Prog Rev: A

B9-6-18

2-Deburr if necessary

3.0

QC2

PR 9-6-18

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

HAND FINISHING

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



Dart Ae	rospace l	Ltd								
W/O:			WC	ORK ORDER CHAN	GES					
DATE STEP		PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•							
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes N	lo DQ	\ :	_ Date:	
	Res	solution:	Disposition:		QA: N/C Closed:				Date:	
NCR:			WORK ORD	ER NON-CONFORM	MANCE	(NCR)	·			
D.475	0750	Description of NC		Corrective Action Section B			Verific	ation	Approval	Annecel
DATE	STEP	Section A Initial Chief Er		Action Description Chief Eng		Sign & Date	& Section C		Chief Eng	Approval QC Inspector
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			1				1			

NOTE: Date & initial all entries

Date: Thursday, 18/06/2009 7:29:32 AM User: Chantal Lavoie **Process Sheet** Drawing Name: DOOR SLUG Customer: CU-DAR001 Dart Helicopters Services Job Number: 48647 Part Number: D2587 Job Number: Seq. #: Machine Or Operation: Description: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment: INSPECT ALODINE 7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:

DATE	STEP		PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					,					
							•			
Part No	:	1	PAR #:	Fault Category:		NCR: Yes	No DQ	A:	Date: _	
	R	Resolution:		Disposition:	.,,	QA: N/C	Closed: 👱		Date: _	

WORK ORDER CHANGES

NCR:	,	WORK ORDER NON-CONFORMANCE (NCR)									
i;		Description of NC		Corrective Action Section B		Verification	A 1	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48647
		,
Description: DOOL SUG	Part Number:	03687
Inspection Dwg: D> Rev: A1	•	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

х	First Article		Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension			inspection	
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Measured by:	rR	Audited by:	511	Prototype Approval:	1				
. Date:	9-6-18	Date:	07/06/19	Date:		7			

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	



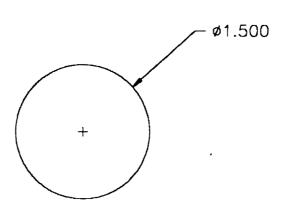




DESIGN MIKE M	DRAWN BY B WILLIAMS	DART AEROSPAC	_
CHECKED	APPROVED	DRAWING NO.	REV. A
10 111	101 101	D2587	SHEET 1 OF 1
DATE		TILE	SCALE
96:07:11		DOOR SLUG	1:1

AI POR 63.09.16. ADD GOGI-TG OFTION

1 14



C209/06/18 W10: 48647

MATERIAL: 5052-H32, 0.040 THICK FINISH: ACID ECTCH, ALODINE

Dart Aerospace Ltd

Dail No	. oopaoc	, = tu										
Ŵ/O:			WORK ORDER CHANGES									
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
Part No):	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	Date: _				
Resolution:			Disposition	_ QA: N/C CI	QA: N/C Closed: Date:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)						
		Description of NC		Corrective Action Sec	Section B		ration	Approval	Approvai			
DATE	STEP	Section A	Section A Initial Action C Chief Eng Chi		Sign & Date			Chief Eng	QC Inspector			
}												
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NOTE: Date & initial all entries